Dart Aerospace Ltd.

Date: Monday, 11/21/2005 2:10:08 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: WEARSHOE
Job Number	: 24863		
Estimate Number	: 10846		
P.O. Number	: N/A	**Part Number**	: D32873
This Issue	: 11/21/2005 **S.O. No.** : N/A	**Drawing Number**	: D3287 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : PURCHASED PARTS	**Drawing Revision**	: B
Previous Run	: N/A	**Material**	: N/A
Written By	: SEE COMMENT BELOW	**Due Date**	: 11/28/2005 **Qty:** 20 **Um:** Each
Checked & Approved By	: SEE COMMENT BELOW		
Comment	: Est: B 05.10.03 Step 7 added KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: 146 — u 05.11.22
Email or ship DXF file to vendor
Laser Cut D3287-3 Flat pattern as per Dwg D3287
Material release note required

2.0	D32873F	WEARPLATE FLAT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
WEARPLATE FLAT

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material release note is attached — DL 05/12/30 20

4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
Inspect dimensions as per template D3287-3 T1 — 06-01-11 15 PTO

5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
Deburr if necessary
Form on Brake as per Dwg D3287 using Jigs DT8261 and DT8326.
Identify as D3287-3
Form Joggle on brake using Jig DT8158 as per Dwg D3287 — SB 06/01/26 19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
06-01-11	4	Took 1 for template. Identify as DT8838 permanent change.		06-01-11	1		06-01-11

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 06/03/13

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 2:10:08 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** WEARSHOE

Job Number: 24863 **Part Number:** D32873

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	06-01-28 15
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3	a.m 06-02-08
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	FC 06 02 10
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP	FC 06 09 10
10.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	Swt 06/02/13 19 06/02/13

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

□□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024863
Project Name : D3287-3
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D3287-3
Description : Wearshoe
Manufactured : No
Amount Req'd : 0
Amount Done : 0
Start Date : 11-17-05
Est Finish Date :
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8099 / 235 3535 Waiuku
Fax: (09) 375 8959

NEW ZEALAND STEEL

TEST CERTIFICATE

Ref: 5379/23650

Reissued 22/8/2005

CUSTOMER	Wilkinson P5C505DI002	SPECIFICATION	ASTMA1008 CS Type A
CUSTOMER O/N	98-21N-742	PRODUCT	CRA WIDE COIL
MILL O/N	486968	DIMENSIONS	0.033" x 48" x Coil

CERTIFICATE No	TC116858
PAGE	1 of 1
DATE	19 August 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)						
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE( )	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000										x10000		x100	180°			G.L.=	HRB	( )	(feet)
R9-466080-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				50		2700
R9-466081-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				50		2700
R9-466082-00	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651
R9-466083-00	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651

16.01.11

YIELD	GAUGE LENGTH (G.L.)			PLASTIC STRAIN RATIO (r)		IMPACT TEST		CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"	(A)=r0	(C)=r45	(A)=10mm x 10mm	(C)=5mm x 5mm	(A)=C+Mn/6	(C)=C+Mn/6+Si/24
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 $\sqrt{So}$	(F)=8"	(B)=r90	(D)=(r0+r90+2r45) / 4	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15	(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Satish Misra
QC METALLURGIST

20 ga

POR 267, 146

51129MD006-1 T M INDUSTRIAL (P5050SDI002.845423)

9029759

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

煒茂實業股份有限公司
YIEH MAU CORP.
工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972185 FAX:(07)697 3006

CERTIFICATE NO:2511152
DATE OF ISSUE:1/12/2004

INVOICE NO. : F04MA65
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304,NO.4 (SIC) FINISH, WITH 100 MIC.FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.AISI 304,2B FINISH, WITH PAPER INTERLEAVED, SLITTED EDGE.
SPECIFICATION : AISI 304
CUSTOMER : INTEGRIS METALS LTD

(ITEM NO) SIZE	NO.	Weight (N.W.) KGS	Weight (N.W.) LBS	Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m Y.S. (N/mm²)	T.S. (N/mm²)	E.L. (%)	HRB	HV	Chemical Composition (%) C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 2B (7425-4228)																		
24GA/48"X120"	1	1,465	3,230	YU231320	3AS444639-21	258	685	56	81	156	4.6	51	119	24	2	804	1821	2.7
24GA/48"X120"	1	1,464	3,228	YU231320	3AS444639-22	258	685	56	81	156	4.6	51	119	24	2	804	1821	2.7
(7425-5860)																		
22GA/48"X96"	1	1,464	3,228	YU230510	38837609B-51	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4
(7425-5951)																		
22GA/48"X120"	1	1,375	3,031	YU230510	38S37609B-52	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4
(7425-5859)																		
22GA/48"X96"	1	1,445	3,186	YU134975	3AS43434A-1	312	666	51	82	161	4.1	49	112	24	2	809	1821	2.8
(7426-2859)																		
18GA/48"X96"	1	1,497	3,300	YU231066	3AS42732-4	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
(7426-2859)																		
18GA/48"X120"	1	1,453	3,203	YU231066	3AS42732-5	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
18GA/48"X120"	1	1,455	3,208	YU231066	3AS42732-6	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
(7426-5166)																		
16GA/48"X120"	1	1,423	3,137	YU231143	3AS42866A-6	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X120"	1	1,424	3,139	YU231143	3AS42866A-7	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X120"	1	1,420	3,131	YU231143	3AS42866B-1	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
(7426-7949)																		
16GA/48"X96"	1	1,441	3,177	YU231075	3AS42917A-1	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
16GA/48"X96"	1	1,441	3,177	YU231075	3AS42917A-2	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
(7426-8053)																		
14GA/48"X120"	1	1,420	3,131	YU231075	3AS42917A-3	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
14GA/48"X120"	1	1,420	3,131	YU231075	3AS42917A-4	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
(7426-8240)																		
14GA/60"X96"	1	1,446	3,188	YU135202	3AS45623A-211	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
(7426-8277)																		
14GA/60"X120"	1	1,405	3,097	YU135202	3AS45623A-213	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
14GA/60"X120"	1	1,540	3,395	YU135202	3AS45623A-214	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
	18	25,996	57,317															

Remarks: NO MERCURY CONTAMINATION — Brad test good for all Heat NO.

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480, A262E, ASME SA240, QQS766D.

YIEH MAU CORP.

Manager of Quality Assurance Section

20ga 304 0455 (0.037)

PO [redacted], 267 196

(13)

NEW ZEALAND STEEL

New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5210/22495

CUSTOMER	Wilkinson P503323DI001	SPECIFICATION	ASTMA1008 CS Type A
CUSTOMER O/N	90-21N-686	PRODUCT	CRA WIDE COIL
MILL O/N	480737	DIMENSIONS	0.055" × 48" × Coil

CERTIFICATE No TC112397
PAGE 1 of 1
DATE 09 June 2005

CHEMICAL COMPOSITION PERCENT

PACK NUMBER	HEAT No	C (x100)	Si (x100)	Mn (x100)	P (x1000)	S (x1000)	Cu (x1000)	Ni (x1000)	Cr (x1000)	Mo (x1000)	V (x1000)	Nb (x1000)	Ti (x1000)	Al (x1000)	B (x10000)	N2 (x10000)	CE( ) (x100)
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1				
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1				
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1				
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1				
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1				
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1				
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1				
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1				
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1				
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1				
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1				
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1				

MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)

PACK NUMBER	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB	r ( )	LENGTH (feet)
R9-459713-00	Good				54		1585
R9-459714-00	Good				54		1457
R9-459715-00	Good				48		1375
R9-459716-00	Good				48		1473
R9-459717-00	Good				48		1631
R9-459718-00	Good				48		1093
R9-459719-00	Good				50		1562
R9-459720-00	Good				50		1535
R9-460380-00	Good				50		1581
R9-460381-00	Good				49		1562
R9-460382-00	Good				49		1503
R9-461458-00	Good				48		1785

PO: 227181
RN: 55103IMD009

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65√So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45) / 4	IMPACT TEST (A)=10mm x 10mm (C)=5mm x 5mm (B)=7.5mm x 10mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Satish Misra
QC METALLURGIST

16 ga ms   poff 146, 267, 245,

131MD009-1 T M INDUSTRIAL (P503323DI001: 641756)